

Date: Wednesday, 3/14/2007 3:32:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HOOK		
Job Number	: 31229					
Estimate Number	: 12597					
P.O. Number	: N/A			Part Number	: D30465	
This Issue	: 3/14/2007	S.O. No.	: N/A	Drawing Number	: D3046 REV B	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: 3/14/2007	Type	: SMALL /MED FAB	Drawing Revision	: B	
Previous Run	: 31095			Material	: N/A	
Written By	:			Due Date	: 3/30/2007	
Checked & Approved By	: <u>John</u> , 03/15			Qty:	30	Um: Each
Comment	: Est A 06.12.01 New Issue EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M174B0375X1000	17-4 SS Bar 3/8 x 1"	
		Comment: Qty.: 0.1397 f(s)/Unit Total : 4.1895 f(s) 17-4PH Stainless Steel Bar 3/8" x1.00" Batch: M102942	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blank 1.600" long	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1- Mill as per Folio FA659 Rev: <u>A</u> & Dwg D3046 Rev: <u>B</u>	
			<u>J.F. 07/03/21</u> (29)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>J.F. 07/03/21</u> (29)
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>J.L. 07/03/22</u> 29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/13/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:32:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOOK

Job Number: 31229

Part Number: D30465

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P173/23

SD

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(29)

Comment: FINAL INSPECTION/W/O RELEASE

D07163126

Job Completion



U 07-02-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

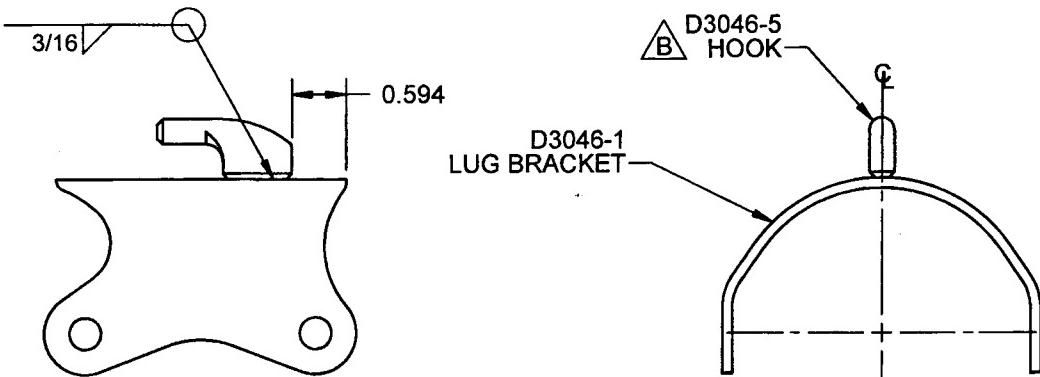
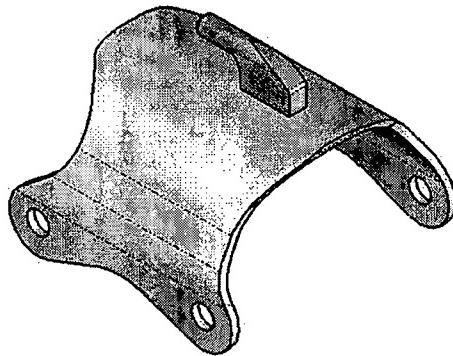
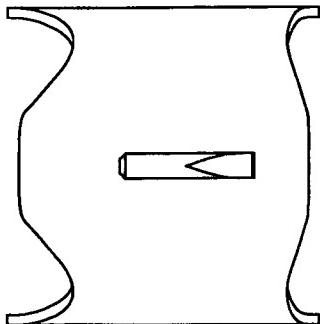
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>J.D.H.</i>	APPROVED <i>CH</i>	DRAWING NO. D3046
DATE 06.10.26		REV. B SHEET 1 OF 3
		TITLE LUG BRACKET ASSEMBLY
SCALE 1:2		
REV	DATE	DESCRIPTION
A	01.08.23	NEW ISSUE
B	06.10.26	ADD D3046-5 REMOVE D3046-3; INCREASE HOLE DIAMETER OF D3046-1; CHANGE MATERIAL TO 17-4PH FROM 1010 STEEL

RELEASED

06.11.13 *CH*

D3046-041 LUG BRACKET ASSEMBLY

QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK

B

NOTES:

- 1) FINISH: HEAT TREAT ASSEMBLY TO H900 HARDENED CONDITION (MIN 190 KSI)
POWDER COAT ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMMETRICAL ABOUT C
- 6) IDENTIFY WITH P/N D3046-041 USING FINE POINT PERMANENT INK MARKER NO. *31229*

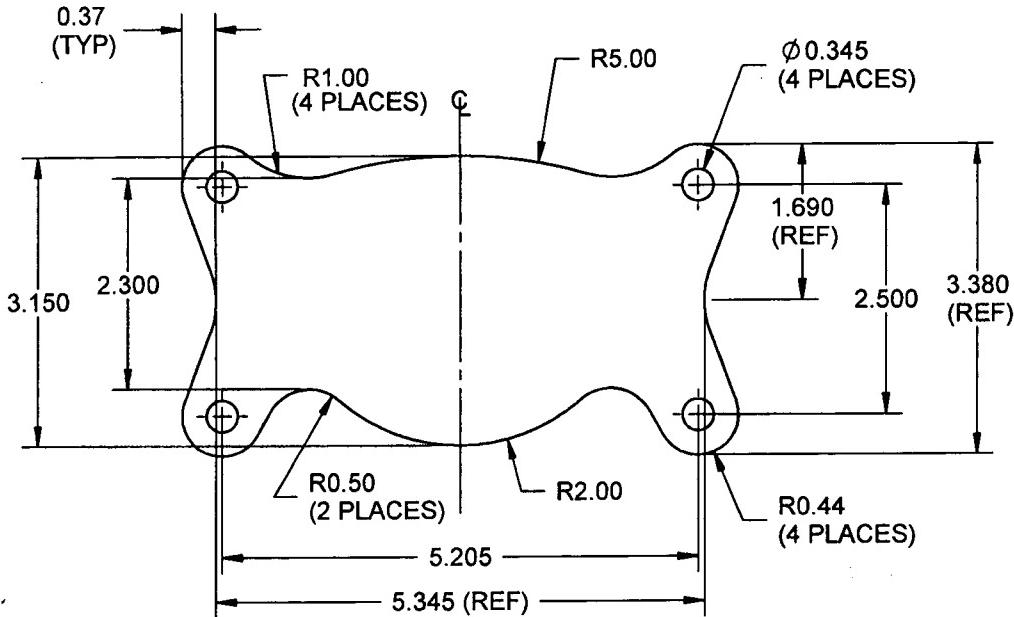
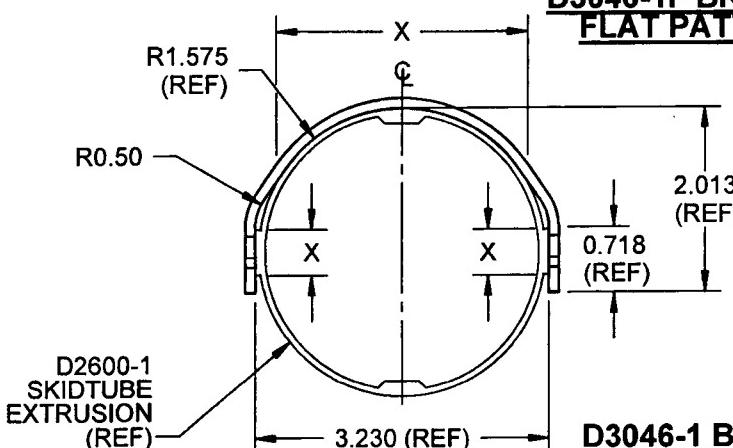
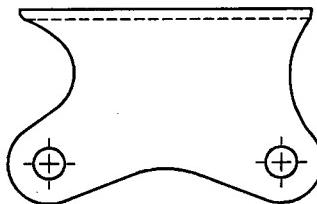
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WITHOUT NOTICE

WORK ORDER

DART

DESIGN <i>A</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JLH</i>	APPROVED <i>H</i>	DRAWING NO. D3046	REV. B SHEET 2 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY	SCALE 1:2	

**D3046-1F BRACKET
FLAT PATTERN****D3046-1 BRACKET
BEND DETAIL****RELEASED**

06/11/13

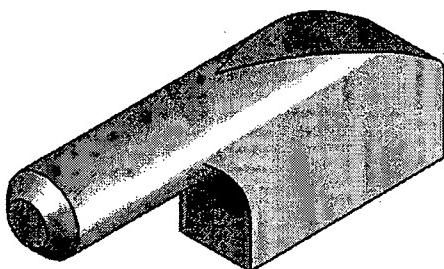
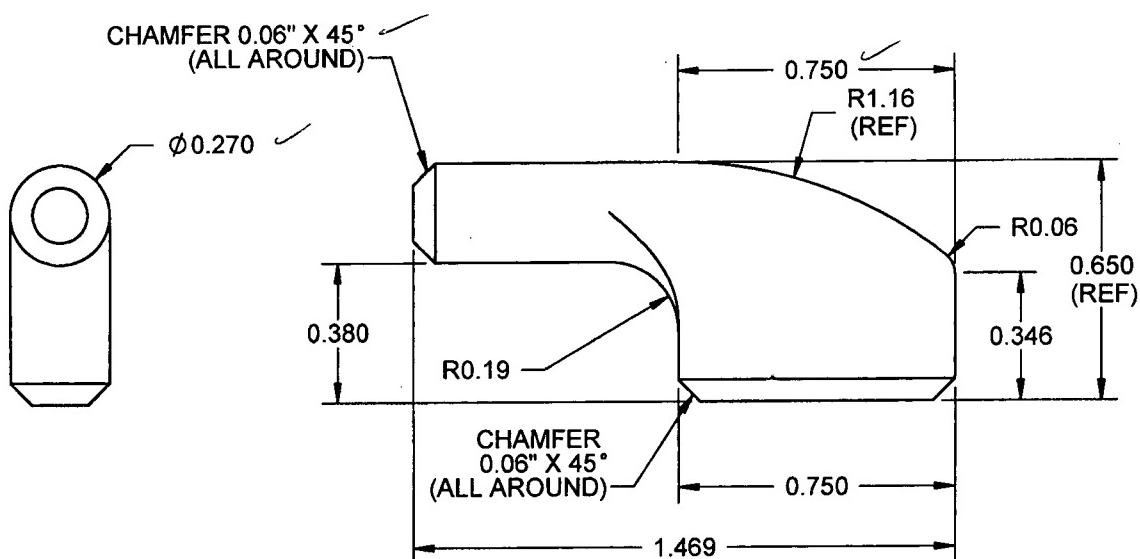
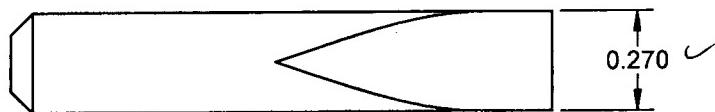
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WORK ORDER
NO 31229

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 0.109" THICK
(12 GAUGE) PER AMS 5604 (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) D3046-1 SHOULD BE BENT USING DT8351 TOOL SO THAT IT IS WITHIN 0.010" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X'.

DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JLH</i>	APPROVED <i>CH</i>	DRAWING NO. D3046	REV. B SHEET 3 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY	SCALE 2:1	

**RELEASED***06.11.13 - CH***D3046-5 HOOK** **NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR PER AMS 5604 OR AMS 5643
(REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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WITHOUT NOTICE
WORK ORDER
NO. *31229*

DART AEROSPACE LTD	Work Order:	31229
Description: Lug bracket assembly	Part Number:	3046-5
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A , 270"	± .010"	, 273"	✓			
B , 060" X 45°	± .030"	, 065"	✓			
C Ø , 270"	± .010"	, 272"	✓			
D , 750"	± .010"	, 750"	✓			
E , 650"	± .010"	, 647"	✓			
F , 346"	± .010"	, 346"	✓			
G , 750"	± .010"	, 753"	✓			
H 1, 469"	± .010"	1, 467"	✓			
I 0.06" X 45°	± .030"	, 050"	✓			
J , 380"	± .010"	, 376"	✓			
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	J.F.	Audited by:	E.P.	Prototype Approval:	N/A
Date:	07/03/20	Date:	07/03/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	